

Work Order ID 65708

January 24, 2011 10:03:18 AM



Page 1

Item ID: D4310-1

Accept



Setup Start



Revision ID:

Item Name: Block

Stop



Start Date: 1/24/11 Start Qty: 90.00



Cust Item ID:

Required Date: 2/10/11 Req'd Qty: 90.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4310

A

90

0.00



Bandsaw

Jeaspa Bandsaw

Memo

cut to 1.50" LONG

0.00

aml 11/02/03

100

100

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLI FB027 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

0.00

aml 11/02/03

94

6

(PTD)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4310-1 PAR #: _____ Fault Category: machining NCR: Yes No DQA: [Signature] Date: 11/02/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 11/02/10

NCR: 65708		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/10	100	6 parts scrap. 3 more during machining 3 come out under tolerance thickness 1.677	<u>[Signature]</u>	Scrap. & critical part &	<u>[Signature]</u> 11/02/10	<u>[Signature]</u> 11/2/10	<u>[Signature]</u> 11/02/10	<u>[Signature]</u> 11/02/10
		R.L. operator error						

NOTE: Date & initial all entries

Work Order ID 65708

January 24, 2011 10:03:19 AM



Page 2

Item ID: D4310-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 1/24/11 Start Qty: 90.00



Cust Item ID:

Required Date: 2/10/11 Req'd Qty: 90.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Am 11/02/03

94

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SA 11/2/10

94

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

CU/410 (94)

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65708

January 24, 2011 10:03:19 AM



Page 3

Item ID: D4310-1

Accept



Setup Start



Revision ID:

Item Name: Block

Stop



Start Date: 1/24/11 Start Qty: 90.00



Cust Item ID:

Required Date: 2/10/11 Req'd Qty: 90.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10
MF

11-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 24, 2011 10:03:18 AM

Page 1

Work Order ID: 65708



Parent Item: D4310-1



Parent Item Name: Block

Start Date: 1/24/11

Required Date: 2/10/11

Start Qty: 90.00

Required Qty: 90.00

Comments: IPP Rev:A 11.01.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MPTFES2.000		Purchased	No			100	f	11.5000	0.1666	15.78316			



Polytetrafluoroethylene Molded Sheet

Location

Loc Qty

Loc Code

MAT

11.5

116533

11.5

11.5 *sm 11/02/03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65708
Description: BLOCK, ANTI-ROTATION		Part Number: D4310-1
Inspection Dwg: D4310, Rev: A		Page 1 of 1

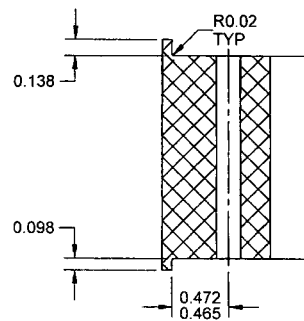
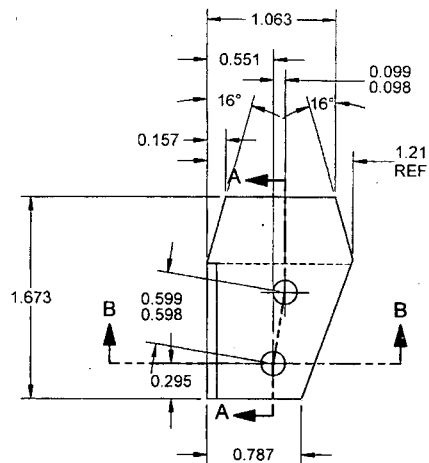
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

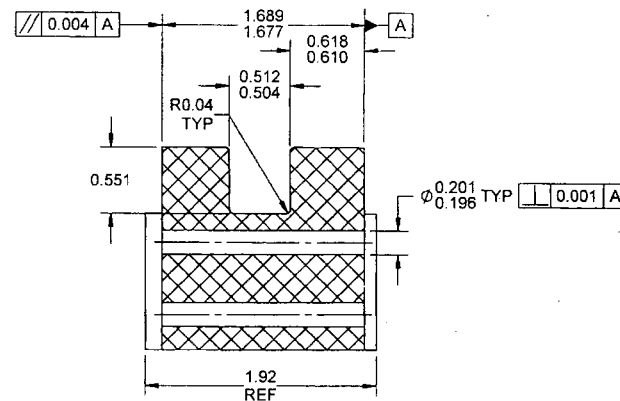
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.673	±.010	1.670	—		Vern	ML-7
.295	±.010	.296	—		"	"
.787	±.010	.787	—		"	"
.598	+ .001 - .000	.599	—		"	"
16°	± 1/2°	16°	—		C-squre	MLEBR
.551	±.010	.551	—		Vern	ML-7
.098	+ .001 - .000	.099	—		"	"
1.21	±.030	1.212	—		"	"
.138	±.010	.140	—		"	"
.098	±.010	.100	—		"	"
.465	+ .007 - .000	.468	—		test-indicator	REF
R.02	±.030	R.020	—		Red-gage	REF
.551	±.010	.546	—		Vern	ML-7
1.92	±.030	1.917	—		"	"
Ø.196	+ .005 - .000	Ø.197	—		"	"
1.677	+ .012 - .000	1.679	—		Micro	ML-02
.610	+ .008 - .000	.616	—		Vern	ML-7
.504	+ .008 - .000	.510	—		"	"

Measured by: <i>ML</i>	Audited by: <i>DA</i>	Prototype Approval:
Date: 11/02/03	Date: 11/21/10	Date:

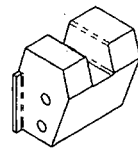
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SECTION B-B



SECTION A-A



D4310-1 BLOCK, ANTI-ROTATION

NOTES:

- 1) MATERIAL: PTFE SHEET, 2.00 THICK X 2.00 WIDE
PER AMS3667
REF DART SPEC MPTFES
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		10.12.16
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4310	REV. A SHEET 1 OF 1
TITLE BLOCK, ANTI-ROTATION	
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
R 2010-12-21
PER ECN 10-673

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries